

Work Order ID 143879

143879

Page 1

Monday, March 28, 2016 10:36:55 AM

Item ID: D044-662-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: R44 Bearpaw Wearplates

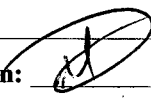
Start Date: 3/28/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/28/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:  Date: 16-3-28 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D044-662	E

100 Document Control 0.00

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & type labels per PPPD044-662-041

CHG 001

DAS
38
9-89

16-03-28

110 Pick Kit 0.00

110

Packaging

Packaging

Memo

0.00

12 Sp 16-03-28

DAS
28
9-89

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Quality Control

Memo

0.00

1

DAS
38
9-89

16-03-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 143879***143879***

Page 2

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: R44 Bearpaw Wearplates

Start Date: 3/28/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/28/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				1			
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D044-662-041								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
28
MAR 28 2016

16/03/28

20160328

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

Picklist Print

Monday, March 28, 2016 10:37:01 AM

Page 1

Work Order ID: 143879

143879

Parent Item: D044-662-041

D044-662-041

Parent Item Name: R44 Bearpaw Wearplates

Start Date: 3/28/2016

Required Date: 3/28/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-01-30 JLM
IPP Rev:B As per Ecn 932 & 862 07-03-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2274 *D2274* Radius Block	68-6 8C SVQ	Manufactured	No			110	Each	313.0000	4	4			DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					DAS 28 9-89
				FG		12							
				86855		12							
				ST006		158							
				140177		158				4X			
				ST012a		143							
				141052		143							
D2529 *D2529* Washer	DAS 38 9-89	Manufactured	No			110	Each	528.0000	4	4			DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					DAS 28 9-89
				ST009		528							
				140554		28				4X			
				141458		500							
D3565-1 *D3565-1* Wearplate	DAS 38 9-89	Manufactured	No			110	Each	15.0000	4	4			DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					DAS 28 9-89
				ST185		15							
				141808		15				4X			

MAR 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Monday, March 28, 2016 10:37:01 AM

Page 2

Work Order ID: 143879

143879

Parent Item: D044-662-041

D044-662-041

Parent Item Name: R44 Bearpaw Wearplates

Start Date: 3/28/2016

Required Date: 3/28/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-12A

Purchased

No

110

Each

136.0000

4

4

AN4-12A

Bolt

DAS
38
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

10

120423

10

ST344

126

m133990

26

m134180

100

4x

DAS
28
9-89

AN4-16A

Purchased

No

110

Each

331.0000

4

4

AN4-16A

Bolt

DAS
38
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

over003

100

M134502

100

ST343

226

M128813

12

M134055

14

M134134

200

4x

DAS
28
9-89

MAR 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
		OTHER : ☐							

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Work Order ID: 143879

143879

Parent Item: D044-662-041

D044-662-041

Parent Item Name: R44 Bearpaw Wearplates

Start Date: 3/28/2016

Required Date: 3/28/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

2,521.000

4

4

MS21042L4

DAS
38
9-89

Locknut

Location

Loc Qty

Loc Code

FP001

37

m133363

37

GA

426

m133769

426

OVER007

1500

m134502

1500

ST303

461

m134055

461

ST305

97

m130922

97

DAS
28
9-89

DAS
28
9-89

4X

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Work Order ID 143879

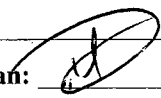
Monday, March 28, 2016 10:36:55 AM

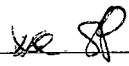
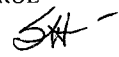
143879

Page 1

Item ID: D044-662-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: R44 Bearpaw Wearplates
 Start Date: 3/28/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/28/2016 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan:  Date: 16-3-28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D044-662	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo 	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD044-662-041	CHG 001							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

16-3-28

REFERENCE ONLY**4.0 WEIGHT AND BALANCE**

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-662-011 Bearpaw Installation	4.6 lb	0.0 in	0.0 in-lb	128.1 in	589 in-lb
	2.10 kg	0.0 m	0.0 m-kg	3.25 m	6.8 m-kg
D044-662-013 Bearpaw Installation	6.2 lb	0.0 in	0.0 in-lb	129.1 in	800 in-lb
	2.81 kg	0.0 m	0.0 m-kg	3.28 m	9.2 m-kg
D044-662-041 Wearplate Kit (installed on D044-662-011/-013 Bearpaw Kit)*	1.6 lb	0.0 in	0.0 in-lb	128.3 in	205 in-lb
	0.73 kg	0.0 m	0.0 m-kg	3.26 m	2.4 m-kg

*D044-662-041 weight and balance should be added to D044-662-011/-013 kits

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Part Number	Description
X			D044-662-011	BEARPAW INSTALLATION
	X		D044-662-013	BEARPAW INSTALLATION
		X	D044-662-041	WEARPLATE KIT
		4	D2274	Radius Block
8	8	4	D2529	Washer
2			D3075-1	Bearpaw
	2		D3529-1	Bearpaw
4	4		D3556-1	Clamp
		4	D3565-1	Wearplate
8	8		D3601-1	Radius Block
4	4		D4953-1	Cushion (Replaces D2182B045 Cushion)
		4	AN4-12A	Bolt
4	4		AN4-14A	Bolt
4	4		AN4-15A	Bolt
		4	AN4-16A	Bolt
8	8		NAS1149D0463J	Washer (Replaces AN960JD416 Washer)
8	8	4	MS21042L4	Nut (or MS21042-4)